

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012951**Date Inspected:** 07-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG CB9.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1: CB 15.

This QA Inspector observed this Cross Beam been shifted to outside yard. No other significant work was being performed on this CB at the time when this QA was present.

Bay 8:

This QA Inspector observed the following work in progress:

Submerged Arc Welding (SAW) of weld joint CB3001B-017-002, for CB17, Top Panel. Welder is identified as 040831. ZPMC Quality Control (QC) is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S-2.

Repair welding of weld no: FB3058-054-012 of Corner Diaphragm Assembly for CB17. Welder is identified as 044581. Welding process was identified as SMAW. ZPMC Quality Control (QC) is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G

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(2F)-repair. This QA Inspector verified the weld repair report (WRR) no: B-WR-11690 R-0 (& UT report no: B787-UT-12074).

Outside Yard:

CB09:

This QA Inspector observed the following work in progress:

Repair welding of weld joint no: CB202A-009 – 001, 002 & 003. Welders were identified as 066268 & 067609. Welding process used was Shielded Metal Arc Welding (SMAW). This QA Inspector verified the critical welding repair report (CWR) no: B-CWR-1380 Rev-0, Dt: 04/07/10. As per Contractors UT report no: CB9-003 Dt: 03/29/10, around 47 nos of locations were identified on this weld for repair. ZPMC Quality Control (QC) is identified as Lin Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair-1.

Repair welding of weld joint no: CB202A-009 – 013, 014 & 015. Welders were identified as 054467 & 037743. Welding process used was SMAW. This QA Inspector verified the critical welding repair report (CWR) no: B-CWR-1380 Rev-0, Dt: 04/07/10. As per Contractors UT report no: CB9-002 Dt: 03/29/10, around 58 nos locations were identified on this weld for repair. ZPMC Quality Control (QC) is identified as Lin Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair-1.

This QA Inspector also observed ZPMC personnel doing heat straightening (HSR) of weld joint no: CB202C-009-002 as per HSR No: HSR1 (B)–7905 Rev-0, DT: 11/18/09. This heat straightening was needed to be done to rectify the weld distortion which was observed as around 5mm to the full length of the weld. QC was identified as Lin Chuan Gang.

Refer attached photos for details.

CB8, CB10, CB11, CB12, CB13, CB14 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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